

RUSH

Work Order ID 107385

107385

Page 1

November-05-13 8:58:08 AM

Item ID: D4463-7

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tank Fwd End

Start Date: 9/23/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/23/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLC

Date: 13-09-24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4463

C

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet
6061.063"

Cut as per dwg

Prog rev: C

Dwg rev: C

2 0 Jm13-11-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2 0 Jm13-11-5

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

27

9-89

131105

2

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Item ID: D4463-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Fwd End
 Start Date: 9/23/13 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 9/23/13 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg Memo	0.00 0.00				2			13/11/05
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		DAS 27 9-89 B115		2			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2		14613-11-5	

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Item ID: D4463-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tank Fwd End
 Start Date: 9/23/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 9/23/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00				2	0		DAS 19
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: WPA.003	0.00				2	0		13-11-05
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13-11-07
 MF
 13-11-0

Picklist Print

November-05-13 8:40:48 AM

Page 1

Work Order ID: 107385

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Parent Item: D4463-7

D4463-7

Parent Item Name: Tank Fwd End

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

456.7305

2.839

6

M6061T6S 063

**

Jm13-11-S

6061-T6.063 Sheet

Location

Loc Qty

Loc Code

MAT021

456.7305

123135

120.2625

124003

72.113

M126075

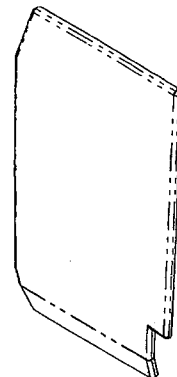
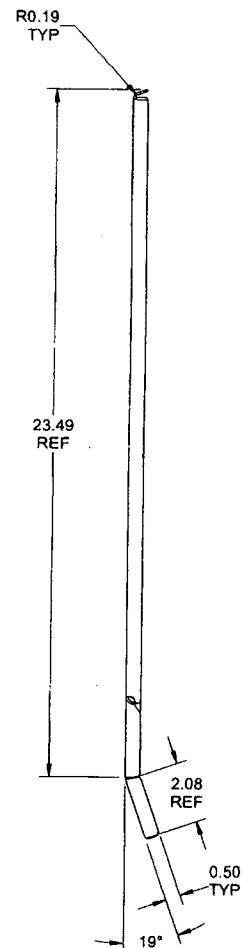
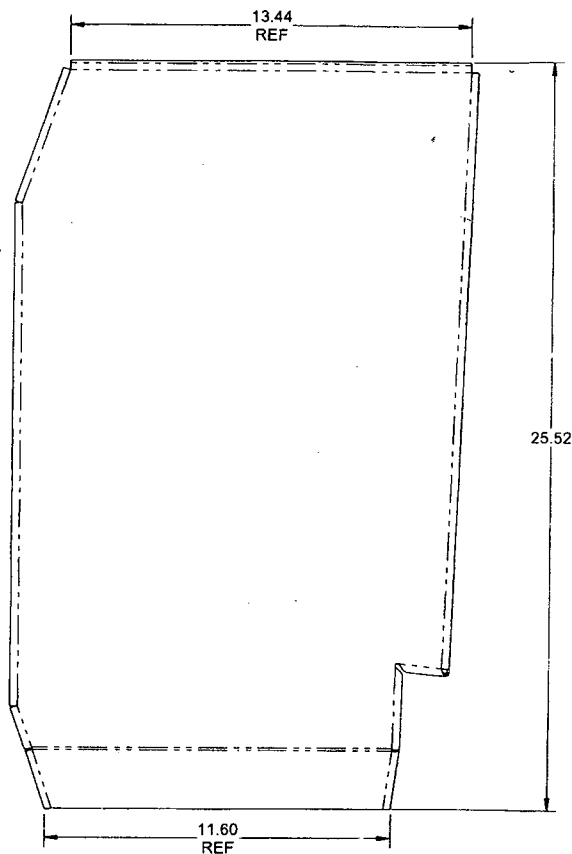
90.365

M127006

173.99

124446

124446 .



D4463-7 TANK FORWARD END

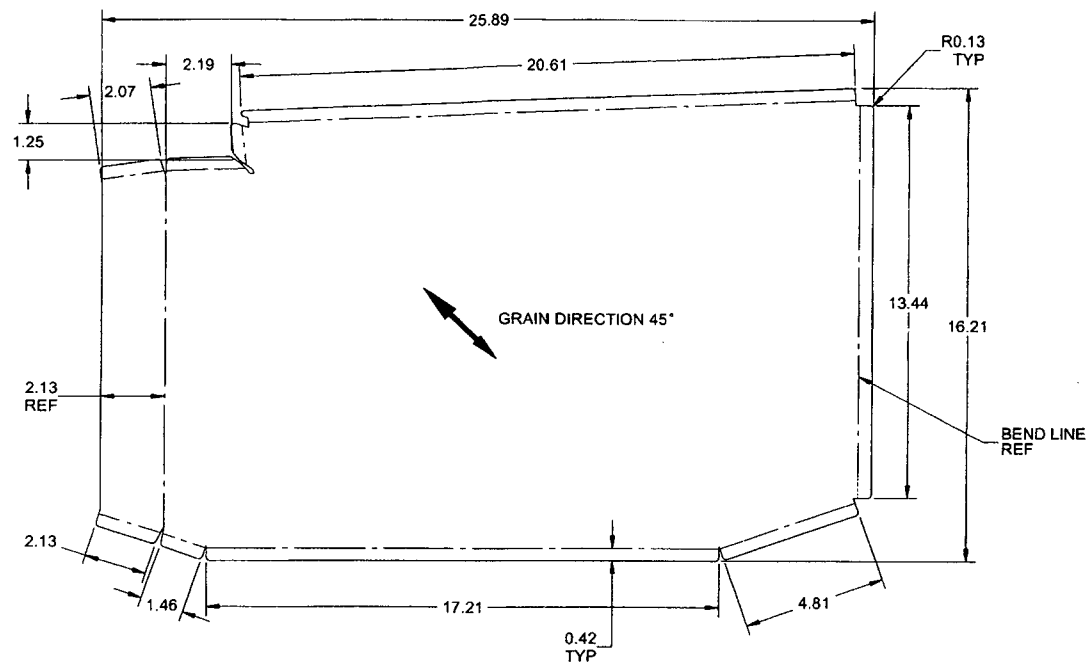
NOTES:

- 1) MATERIAL: MADE FROM D4463-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.41 lbs

107385 MJS
13-09-24

RELEASED
2012-04-24

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	FE	D4463	SHEET 7 OF 14
APPROVED	140	TITLE	SCALE
DE APPR.	140	TANK	NTS
DATE	12.03.23	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4463-7F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.41 lbs
- 8) PROFILE PER DWG FILE "D4463-7F-REV C.DXF"

DESIGN	BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC	DRAWING NO.	REV. C
CHECKED	BC	D4463	SHEET 8 OF 14
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